



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-4-1-PO
Job Sheet 177361



Part No: C3-4-1-PO

Job Qty: 50 ea

Part Name: Load Beam Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/10/18

Job Tracking No:

Due Date: 6/8/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG C3-4-1-PO Rev. C IPP Rev. 4 18.05.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs	6/8/18	6/8/18	0.00	0.00	Purchasing		AT 18/05/18
110	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging2		AT 18/05/18
120	QC	50 pcs	6/8/18	6/8/18	0.00	0.00	QC6		38
130	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3		GA-Alain 18-05-30
140	QC21-FG	50 Ea	6/8/18	6/8/18	0.00	0.00	QC21		18

Part Op 100 - Issue P/O: 039860 MANUFACTURE C3-4-1-PO AS PER DWG Supplier: METEC Certificate of conformity is
Descriptions: required

10 Mai 2018 x 50 R L

DAS
21 MAY 30 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C3-4-1P	Load Beam Bushing	50 pcs (1 ea)	100-Purchasing	5075379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	C3-4-1P	50	7	0

Part Specifications

Specifications could not be found.

Plex 5/10/18 8:48 AM dart.Lussier.Patrick



Container No: S075380



Part: C3-4-1

Job No: 177361

Serial No/Batch: S075380

Revision: 4

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/18

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 9

C3-4-1

Job Sheet 175634



Part No: C3-4-1

Job Qty: 20 ea

Part Name: Load Beam Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/9/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-4-1 Rev 4 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/30/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	20 pcs		4/30/18	0.00	2.00	MORI SL-154		
130	QC	20 pcs		4/30/18	0.00	0.00	QC2 Machining-5		
140	QC	20 pcs		4/30/18	0.00	0.00	QC8 Machining-5		
150	Packaging	20 pcs		4/30/18	0.00	0.00	Packaging3-2		
160	QC21-SA	20 Ea		4/30/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FC038 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.000	Bronze C63000 Round Bar 1.000"	.9320 ft (.0466 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.000	= 2	= 3	0

Part Specifications

Specifications could not be found.

Plex 4/30/18 8:19 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

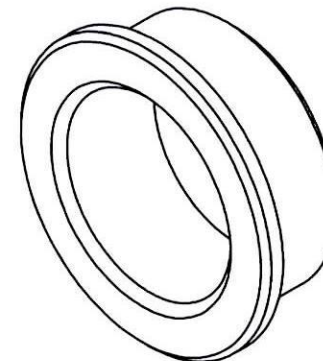
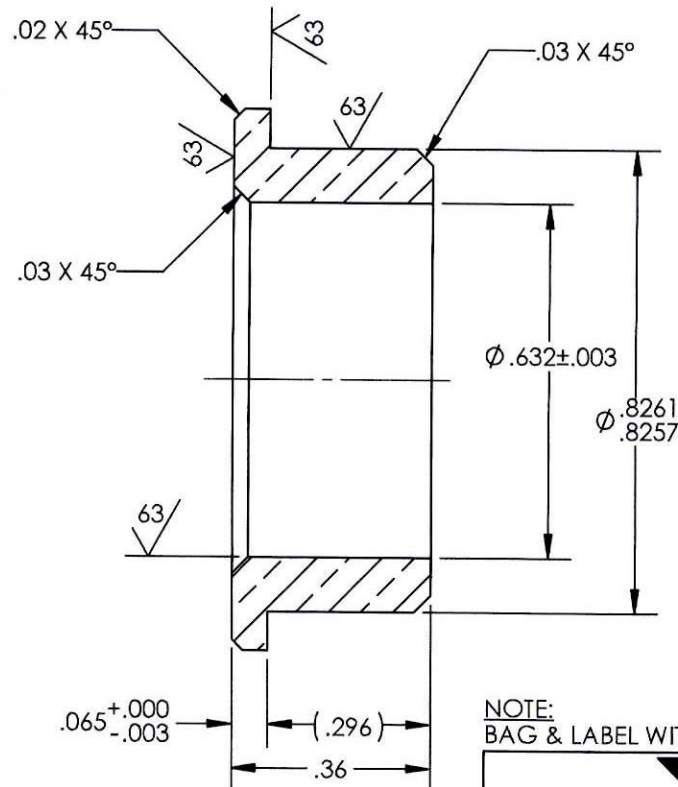
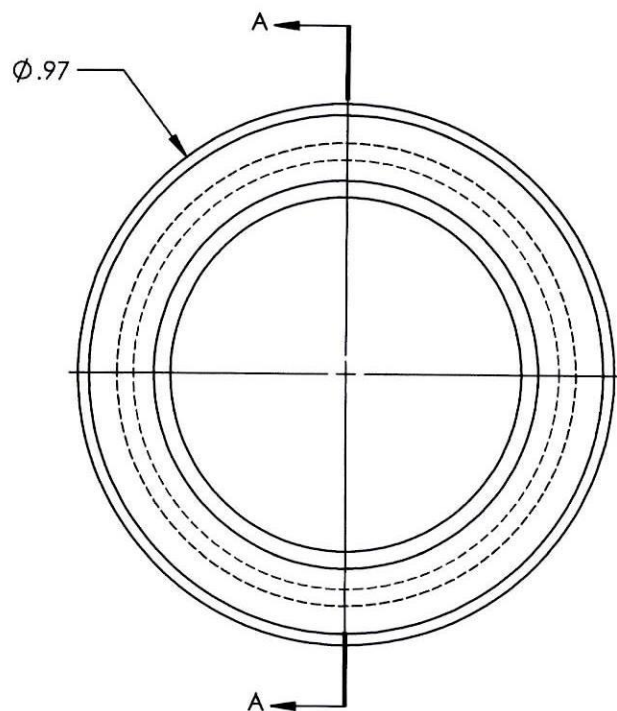
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D Ø.825 +.001/.000 TO Ø.8261 -.8257.	8/15/2012	JAG	
3A	14-0111	CH'D TITLE BLOCK WAS RED. BARN IS DART. ADDED BAG & LABEL NOTE. CH'D DIMENSION TOLERANCE WAS Ø.965 IS Ø.97, WAS .361 IS .36.	8/6/2014	DJN	RW
4	17-0163	CH'D MAT'L WAS AL-BRONZE IS BRONZE 630.	6/23/2017	DPD	JAG



NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOAD BEAM BUSHING	
DWG NO. C3-4-1	REV 4
MAT'L BRONZE 630	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/26/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/06/2017	
SCALE 3:1	DATE 11/12/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-4-1	1	LOAD BEAM BUSHING	BRONZE 630	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039860

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039860

PO Date: 5/10/18

Due Date: 6/8/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	C3-4-1P			Load Beam Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177361											
2	C3-8-2-2P			Solenoid Drilling Jig C3 Hook	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177362											
3	C3-12-2P			Lock Shaft	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177363											
4	C45-3-8BP			Actuator Shaft Bushing Solenoid Side	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177364											
5	C45-3-8AP			Actuator Shaft Bushing	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177367											
6	C45-4-1P			Trunnion Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177369											
7	C10-23-1P			Keeper Spacer	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177373											
8	RBW6305G01232-3G-5P			Spacer	Firmed	6/8/18	25 Ea	0 Ea	25 Ea	\$0.01/Ea	\$0.25
Line Item Note W/O 177396											

DAS
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20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
50	DART C3-4-1P	Load Beam Bushing	39860
32	DART C3-8-2-2P	Solenoid Drilling Jig C3 Hook	39860
40	DART C45-3-8BP	Actuator Shaft Bushing Solenoid Side	39860
40	DART C45-3-8AP	Actuator Shaft Bushing	39860
50	DART C45-4-1P	Trunnion Bushing	39860

DAS
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9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, May 25, 2018